

Work Order ID 82682

82682

Page 1

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

DAS 16 12/04/05
9-10 SR

B82682

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682***82682***

Page 2

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail C to 0.500" (8 holes per side)9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297"

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

Handwritten: 11-04-12
PTQ

Handwritten: B 12/08/29

W/O: 82682

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	110	WORK ORDER SHOULD HAVE CLEAR INFORMATION REGARDING PART INFORMATION IF IT IS FOR LEFT HAND PART IT SHOULD BE DESCRIBED IN DOCUMENT AS THIS.					

Part No: D350-636-011 PAR #: _____ Fault Category: SKID tube NCR: Yes No DQA: Not Date: 12/09/18
 Resolution: _____ Disposition: Scrap QA: N/C Closed: ck Date: 12/9/18

NCR: 12-1815

WORK ORDER NON-CONFORMANCE (NCR) \$15.90

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/18	110	RH float hole drilled in LH SKIDTUBE, fwd of fwd saddle area. RC MISSING INFORMATION	<u>W</u> 12-8-29	SCRAP. Filling with weld would create heat affected zone in stressed area. CP 12.7.18	<u>B</u> 12/08/19	<u>DP</u> 12-8-29	<u>W</u> 12-08-29	<u>DAS</u> 12-08-29
				Replace D2600-3-Bent B# <u>88712</u>				

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 3

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M12016 M120054 BE 12/04/10

12-Grind welds flush as per Dwg D2750

BE 12/08/29

M122399

BE 12/08/29

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
16
9-83

12/08/30

DAS
16
9-83

12/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH

Stop *NS2*

Start Date: 04/04/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 18/04/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept	Qty
--------	-----

Reject
QtyReject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 Ba/08/30

1 ~~0~~ 120830

DAS
18
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 5

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M122428
exp. date: 14-3-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M122399

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 12/09/04

CF 12.8.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 6

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

12/09/0x

DAS 16 17/02/05

DAS 15 17/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 7

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LFI

Stop

NS2

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 3:00								
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1 76 12.9-5

1X 12/09/05

1X 12/09/05

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 9

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82682

82682

Page 10

April-04-12 1:57:53 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

12/9/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 1

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	46.0000	8	8			
D3492-1									**			12/09/04	
Plug													

Location

Loc Qty

Loc Code

FP002

46

B88541

x 8

69531

8

74444

2

76235

4

77037

32

D3492-3		Manufactured	No			230	Each	1.0000	8	8			
D3492-3									**			12/09/06	
Plug													

Location

Loc Qty

Loc Code

FP-A

1

78600

1

B83529

x 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 2

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8

NAS1611-010

O-RING

**

11/09/10

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

225

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

52

121259

50

11/12/15

x 8

NAS1149D0863J

Purchased

No

250

Each

219.0000

2

2

NAS1149D0863.J

WASHER

**

DP

Location

Loc Qty

Loc Code

ST298

219

118078

36

119307

83

120308

100

2x

D2744

Manufactured

No

110

Each

46.0000

1

1

D2744

Cap

**

Location

Loc Qty

Loc Code

LG002

46

62715

1

70881

3

78900

42

BE 12/08/29
8834/2 x 1

April-04-12 1:57:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

15.0000

1

1

D2600-3-BENT

Extrusion Bent

Location

Loc Qty

Loc Code

LG

15

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

**

① 12-04-17
B 12/08/29

D2743

Manufactured No

160

Each

346.0000

8

8

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

346

67766

4

68251

3

73403

64

74445

1

78603

2

79517

62

**

BE 12-07-04
B 386896 x8

D2739

Manufactured No

160

Each

5.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

5

72155

1

81508

1

82122

3

**

CF 12-8-31

B87734

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 4

Work Order ID: 82682

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

82682

D350-636-011

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

90.0000

4

4

D3490-3

Cross Bolt Spacer

**

LocationLoc QtyLoc Code

LG

88

82016

88

LG001

2

78800

2

D3490-1

Manufactured No

160

Each

124.0000

4

4

D3490-1

Cross Bolt Spacer

**

LocationLoc QtyLoc Code

LG

115

81976

115

LG001

9

62450

2

74875

4

77042

3

ALS4-1032-225

Purchased No

220

Each

2,477.000

38

38

ALS4-1032-225

Insert

**

LocationLoc QtyLoc Code

ST281

2454

108696

146

110768

62

118386

55

118966

68

120671

123

121269

2000

ST282

23

120410

10

120451

13

M122290

x38

April-04-12 1:57:57 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 5

Work Order ID: 82682

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

82682

D350-636-011

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

D3793-3

Wearshoe

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP001

23

B33394

XL

80434

11

82166

12

FP002

7

78935

7

AN8C35A

Purchased No

230

Each

56.0000

1

1

AN8C35A

BOLT

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP002

55

M121275

XL

115960

1

117834

8

118286

46

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured No

230

Each

26.0000

1

1

D3793-1

Wearshoe

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP001

26

B33903

XL

78901

10

82171

16

April-04-12 1:57:57 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 6

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

11.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP002

11

B83407

XL

61689

1

75056

2

77021

8

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP002

23

B86243

XL

74530

2

80436

21

AN6C44A

Purchased No

230

Each

175.0000

4

4

AN6C44A

BOLT

**

HL 12/09/06

Location

Loc Qty

Loc Code

FG

2

M122491

XL

103964

2

ST343

173

120143

25

120465

27

120641

1

121013

20

121167

100

April-04-12 1:57:57 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

115.0000

1

1

MS21083C8

NUT

**

xl 12/09/06

Location

Loc Qty

Loc Code

304

50

M122141

x)

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

D3536-25

Manufactured

No

230

Each

22.0000

1

1

D3536-25

Gasket

**

xl 12/09/06

Location

Loc Qty

Loc Code

FP

14

81342

14

FP002

8

78902

8

x1

1387053

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230 Each 243.0000 8 8

D3631-1

Washer

**

HL 12/09/06

Location

Loc Qty

Loc Code

FG

100

1383588

x8

81874

100

ST072

143

68062

2

75548

141

D3791-1 Manufactured No

230 Each 9.0000 1 1

D3791-1

Wearplate

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP002

9

1383902

x1

62239

2

78897

7

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

*AN960C10L * -X

washer

11122063

**

(x38) HL 12/09/06

D2745 Manufactured No

230 Each 64.0000 8 8

D2745

Bushing

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP

62

79518

62

1385416

x8

FP001

2

69529

1

76142

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,602.000

34

34

AN3C5A

Bolt

**

ML 12/09/06

Location

Loc Qty

Loc Code

FP001

7

11122141

x34

115835

7

ST350

1595

116419

28

117343

13

117764

7

117872

2

119749

23

120423

522

1210168

500

121255

500

D3537-1

Manufactured

No

230

Each

26.0000

3

3

D3537-1

Wearpad

**

ML 12/09/06

Location

Loc Qty

Loc Code

FG

10

79833

10

B88562

x3

FP002

16

69817

5

80337

11

NAS1149C0832R

Purchased

No

230

Each

295.0000

1

1

NAS1149C0832R

WASHER

**

ML 12/09/06

Location

Loc Qty

Loc Code

ST297

295

114915

295

x1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

517.0000

4

4

AN3C6A

BOLT

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

516

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

27

120693

400

X4

NAS1611-013

Purchased

No

230

Each

250.0000

8

8

NAS1611-013

O-RING

**

HL 12/09/06

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

11121826

X8

121166

100

121259

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:57:57 PM

Page 11

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

22.0000 1 1

D3535-25

Wearshoe

**

YH 12/09/06

Location

Loc Qty

Loc Code

FP001

22

B83387

VI

62233

1

80331

10

81357

11

D3794-1

Manufactured No

230 Each

16.0000 1 1

D3794-1

Gasket

**

YH 12/09/06

Location

Loc Qty

Loc Code

FP002

16

75042

4

80435

12

B83395

VI

MS21043-6

Purchased No

230 Each

773.0000 4 4

MS21043-6

NUT

**

YH 12/09/06

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

753

112314

47

117887

6

118384

200

120308

500

YH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

54.0000 2 2

D3493-1

Washer

**

383097 sp

Location

Loc Qty

Loc Code

ST050

54

70697

2

77573

12

78835

40

MS21083C8

Purchased No

250 Each

115.0000 2

MS21083C8

NUT

**

(2) m122452 sp
12-9-11

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

April-04-12 1:57:57 PM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

79.0000

2

**

S *AN8C21A*
BOLT

6 m 122204 SP h

Location

Loc Qty

Loc Code

ST343

79

118758

5

120094

34

121067

20

121167

20

NAS1515H3L

Purchased

No

230

Each

198.0000

4

4

**

*NAS1515H3I *
WASHER

HL 12/09/04

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

158

118686

3

119438

1

120072

8

120360

96

121243

50

D2741

Manufactured

No

250

Each

67.0000

1

**

S *D2741*
Blade, 350 Skidtube

1 B85480 SP h

Location

Loc Qty

Loc Code

ST

-10

ST466

77

71856

1

76984

26

79516

40

April-04-12 1:57:57 PM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 14

April-04-12 1:57:57 PM

Work Order ID: 82682

82682

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

55.0000

2

2

D3532-1

Spacer

**

385484 SP

12-9-11

Location

Loc Qty

Loc Code

ST053

55

78839

31

82041

24

April-04-12 1:57:57 PM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

82682 MLCJ
12/04/05

RELEASED

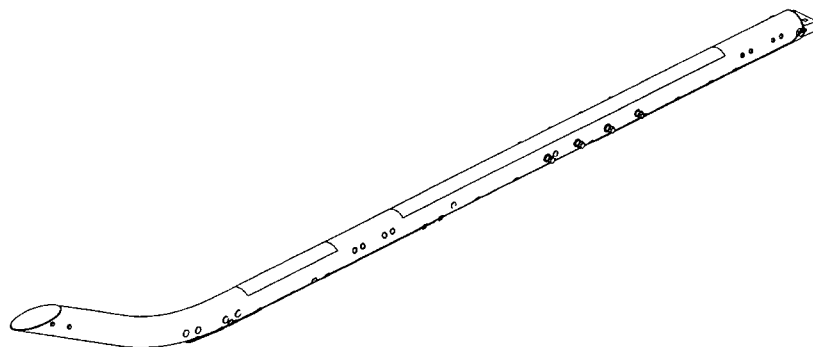
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 91339157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

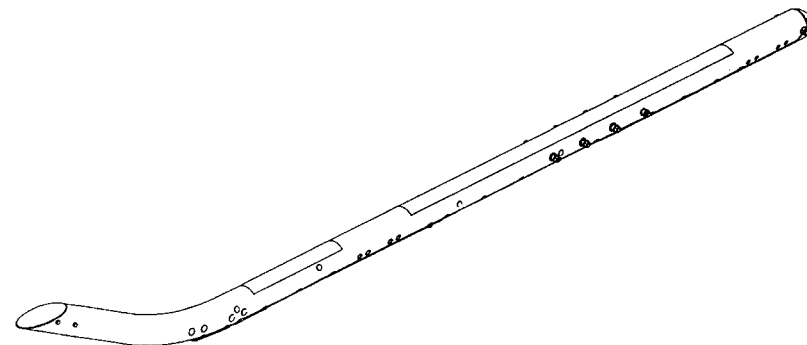
DRAWING NO. **D2750** REV. F
SHEET 1 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

82682



D2750-041 350 SKIDTUBE ASSEMBLY, LH

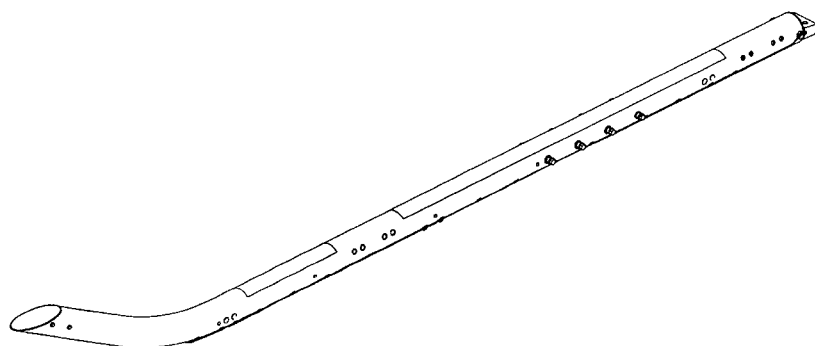


D2750-042 350 SKIDTUBE ASSEMBLY, RH

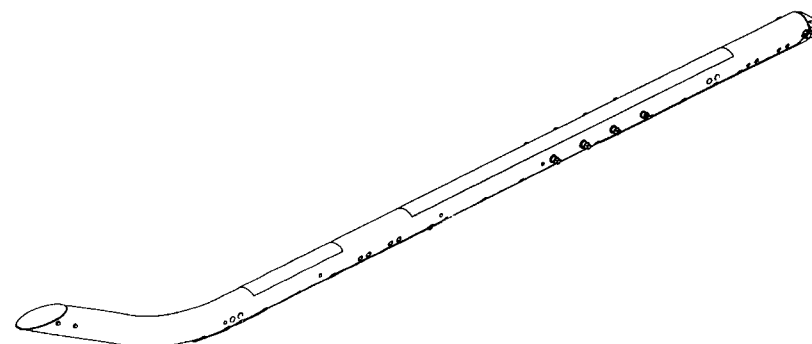
RELEASED
15-9-22-14

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	SA	D2750	SHEET 2 OF 11
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

02682



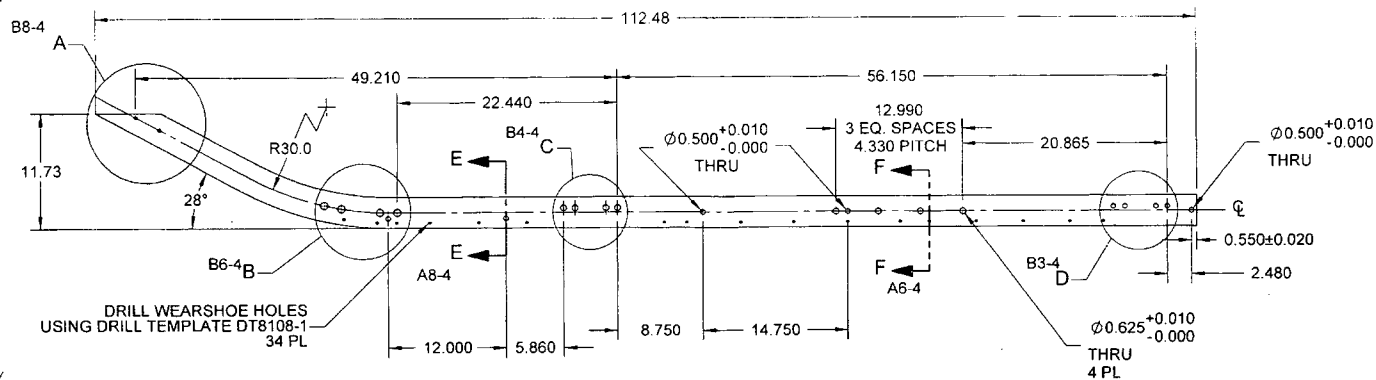
D2750-043 350 SKIDTUBE ASSEMBLY, LH



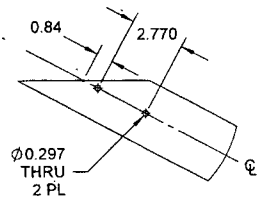
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-09-22/100

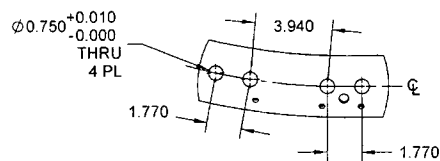
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



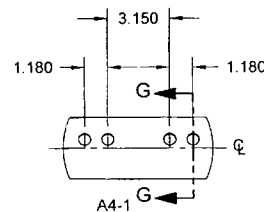
D2750-1 LH SKIDTUBE



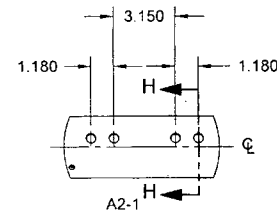
DETAIL A
SCALE 2X



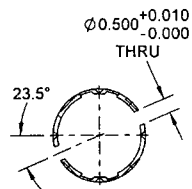
DETAIL B
SCALE 2X



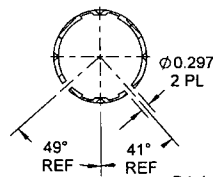
DETAIL C
SCALE 2X



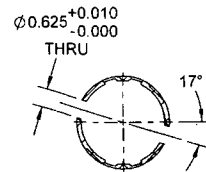
DETAIL D
SCALE 2X



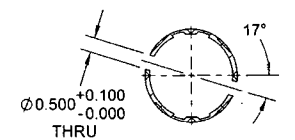
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



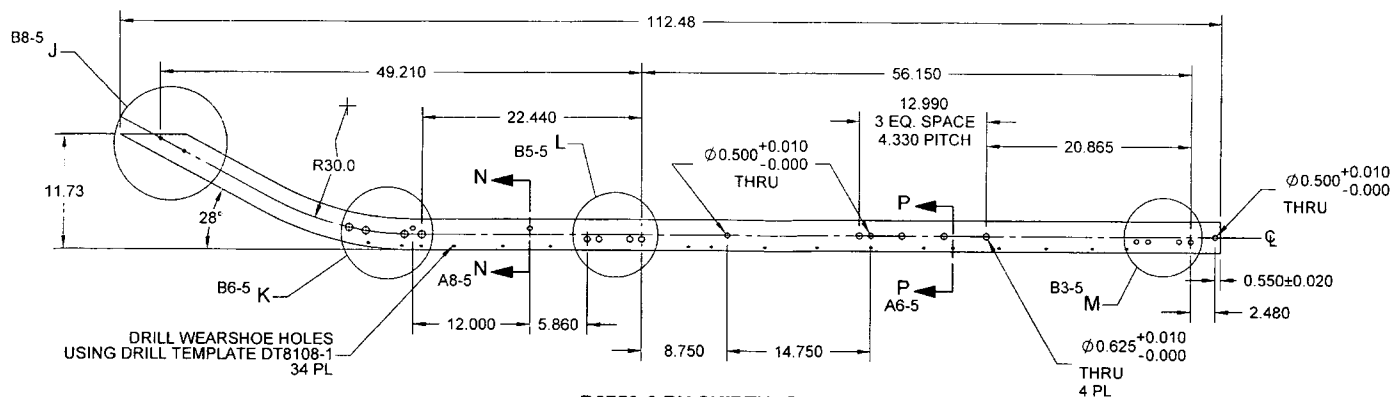
SECTION H-H
SCALE 3X, 4 PL

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 4 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

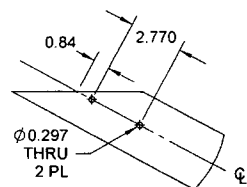
02682



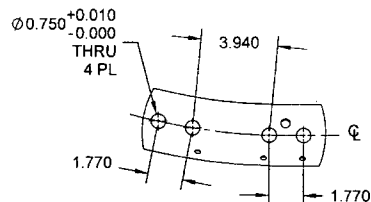
RELEASED



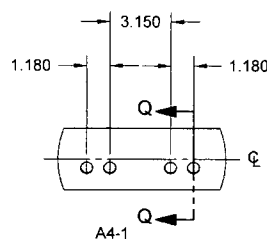
D2750-2 RH SKIDTUBE



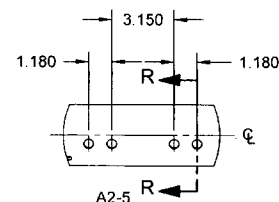
DETAIL J
SCALE 2X



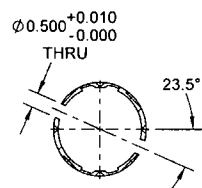
DETAIL K
SCALE 2X



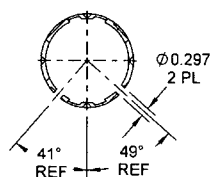
DETAIL L
SCALE 2X



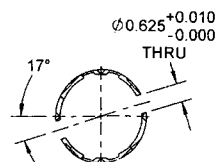
DETAIL M
SCALE 2X



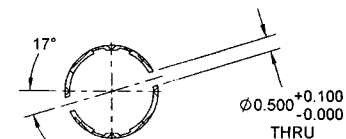
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



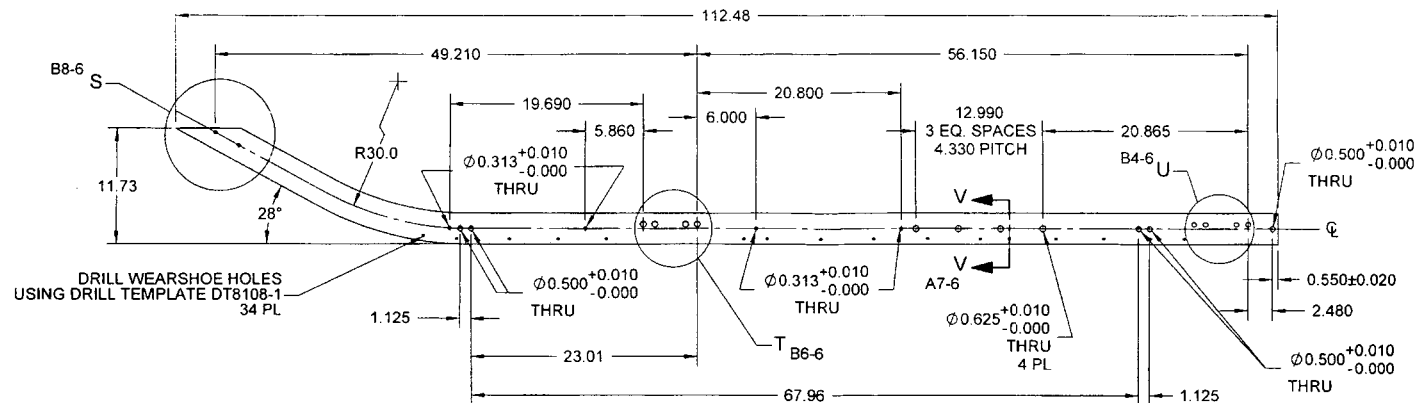
SECTION Q-Q
SCALE 3X, 4 PL



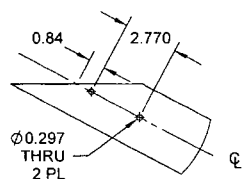
SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

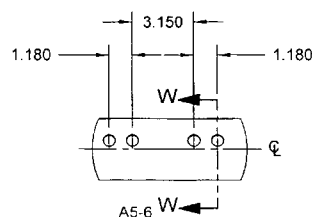
RELEASED



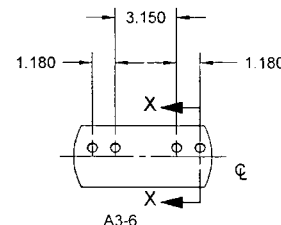
D2750-3 LH SKIDTUBE



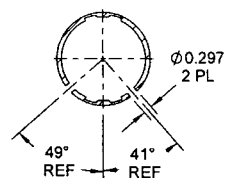
DETAIL S
SCALE 2X



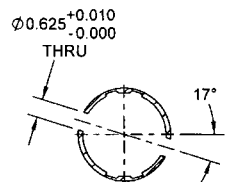
DETAIL T
SCALE 2X



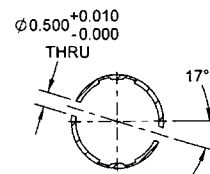
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



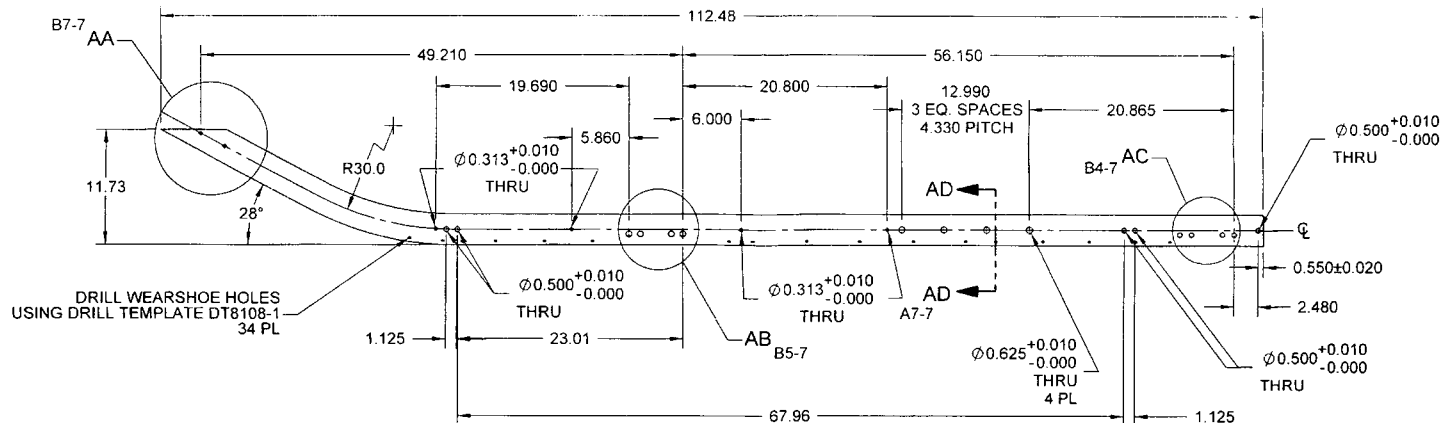
SECTION W-W
SCALE 3X, 4 PL



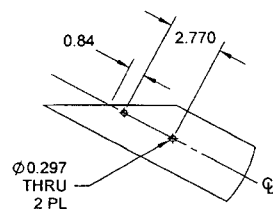
SECTION X-X
SCALE 3X, 4 PL

RELEASED

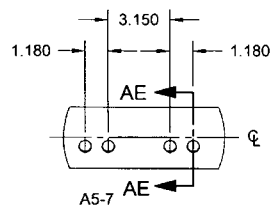
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE	SHEET 6 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



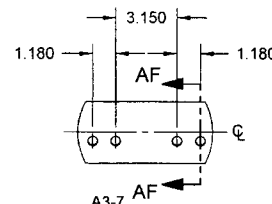
D2750-4 RH SKIDTUBE



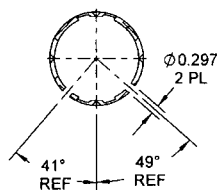
DETAIL AA
SCALE 2X



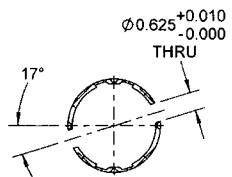
DETAIL AB
SCALE 2X



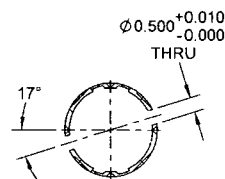
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

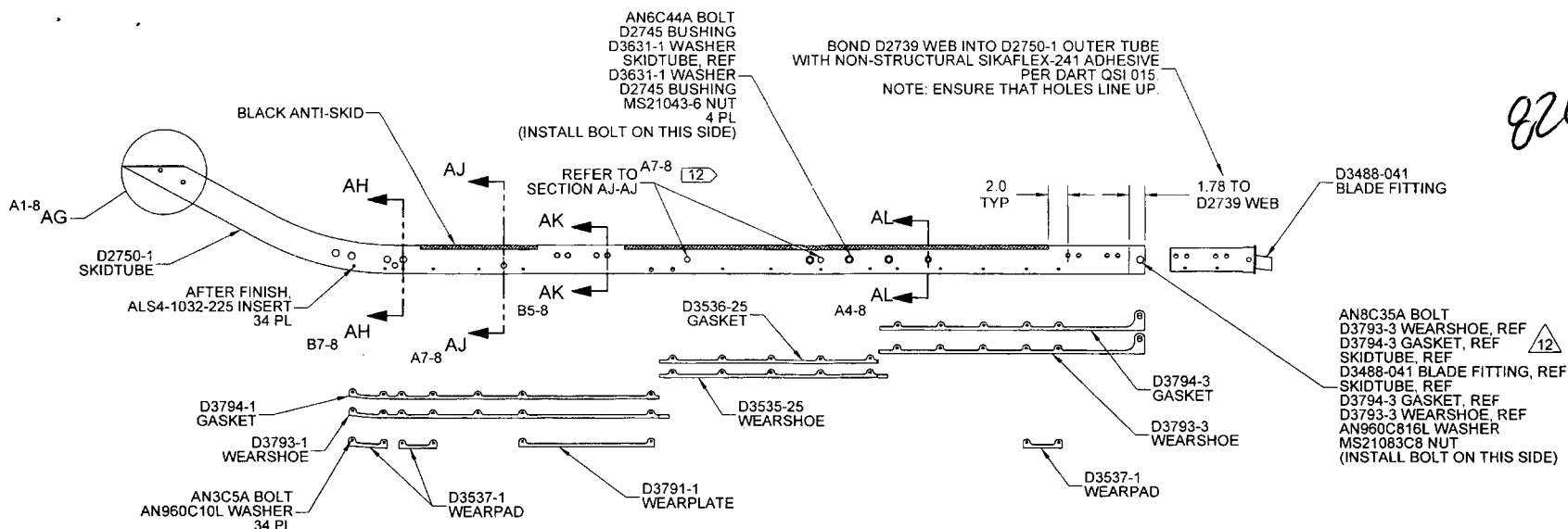


SECTION AF-AF
SCALE 3X, 4 PL

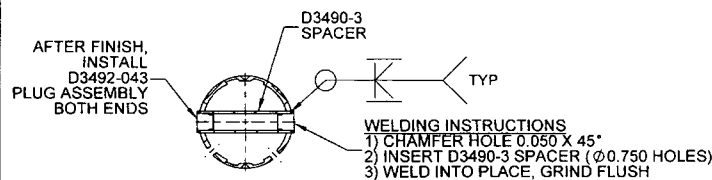
RELEASED
06-09-22-110

DESIGN	PAH	DART AEROSPACE USA, INC.	
DRAWN	PAH	PORT HADLOCK, WA	
CHECKED	PAH	DRAWING NO.	REV. F
MFG. APPR.	PAH	D2750	SHEET 7 OF 11
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

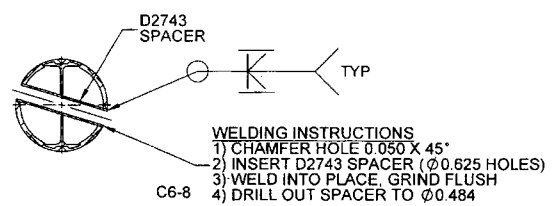
82082



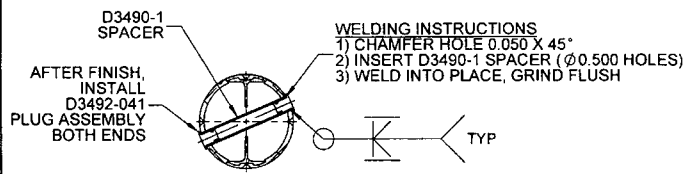
D2750-041 350 SKIDTUBE ASSEMBLY, LH



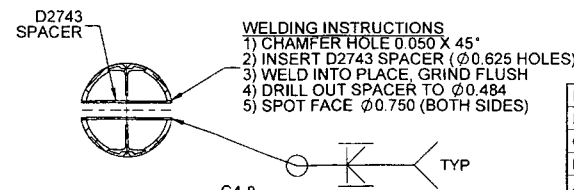
SECTION AH-AH
SCALE 3X, 4 PL



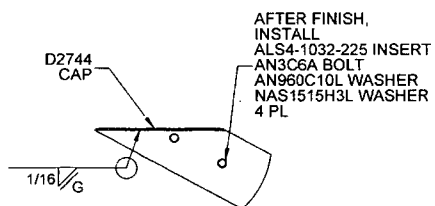
SECTION AK-AK
SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



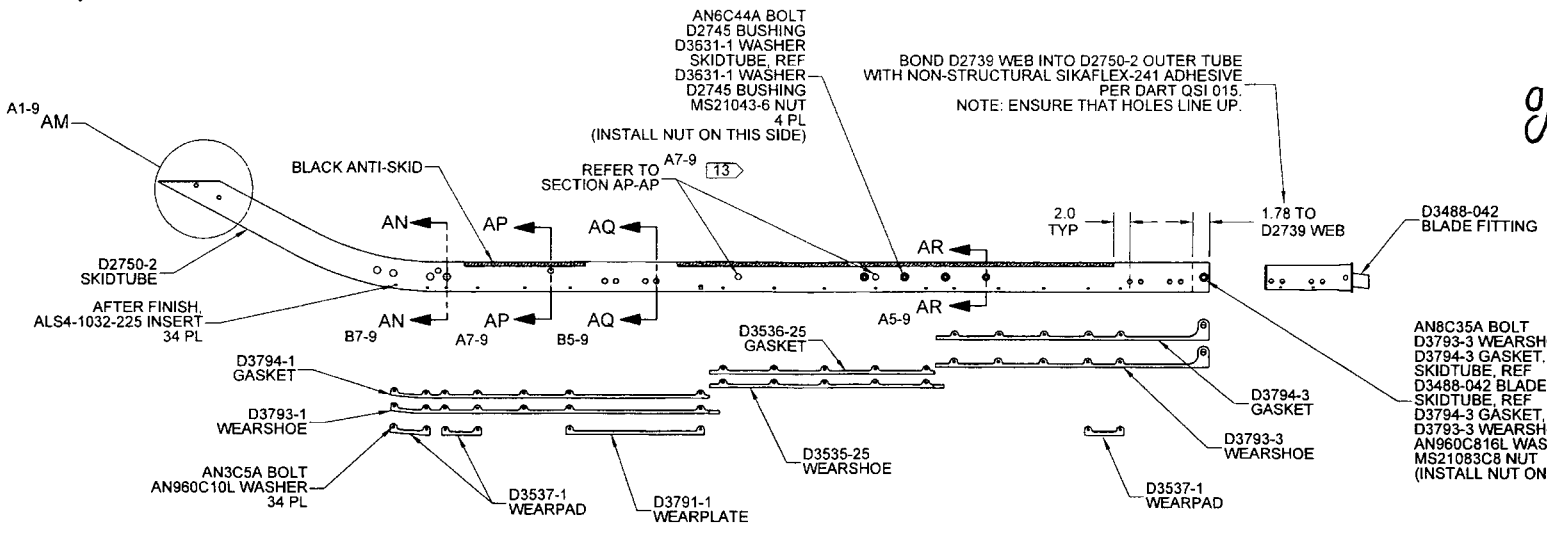
SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



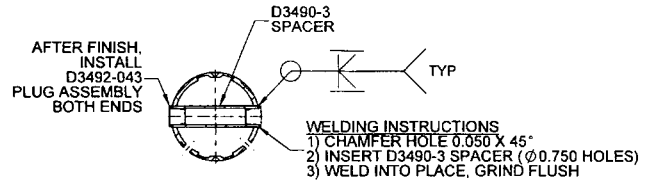
RELEASED
D8-8
DETAIL AG
SCALE 2X

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 8 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

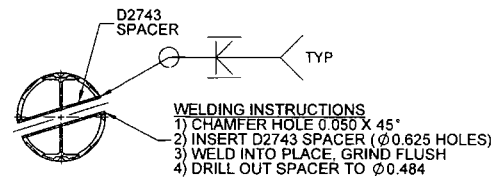
02682



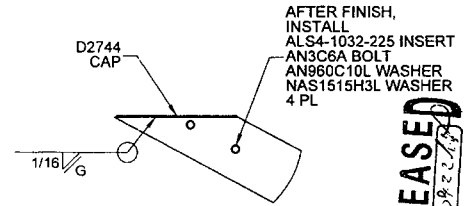
D2750-042 350 SKIDTUBE ASSEMBLY, RH



SECTION AN-AN
SCALE 3X, 4 PL

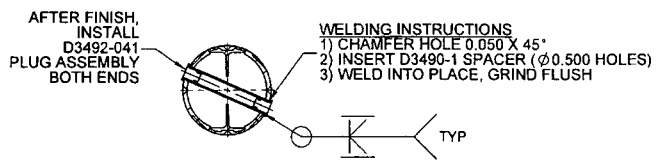


SECTION AQ-AQ
SCALE 3X, 4 PL

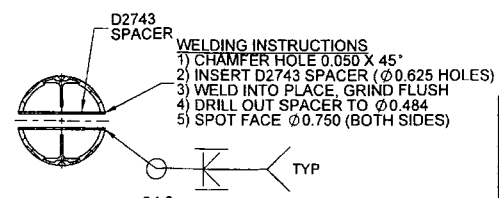


DETAIL AM
SCALE 2X

RELEASED



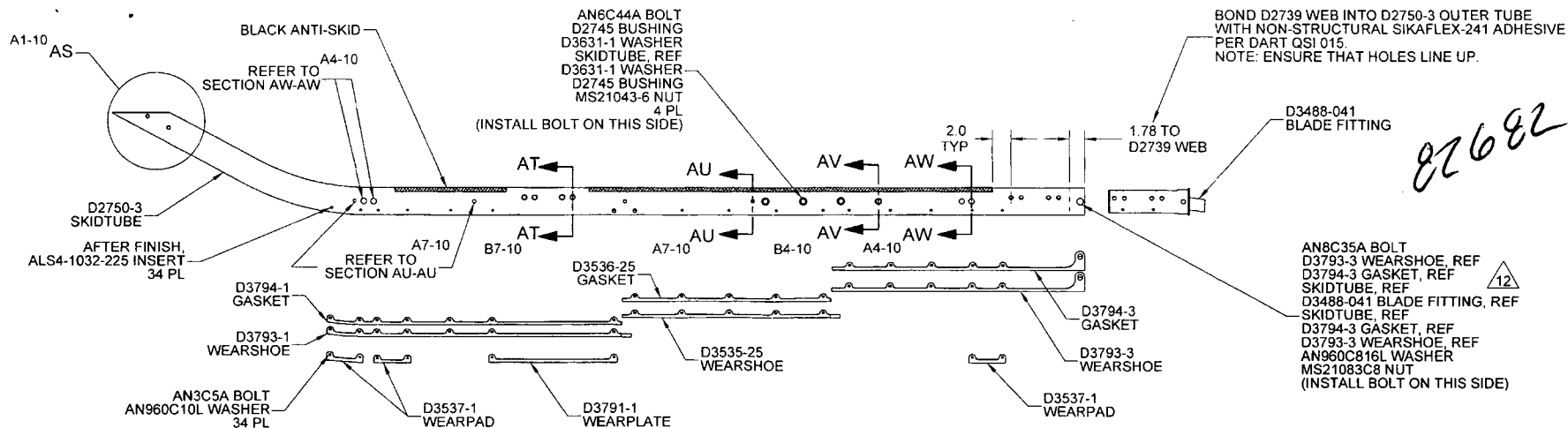
SECTION AP-AP
SCALE 3X, 4 PL



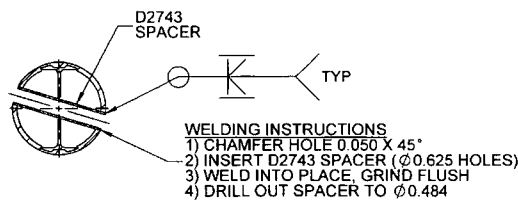
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

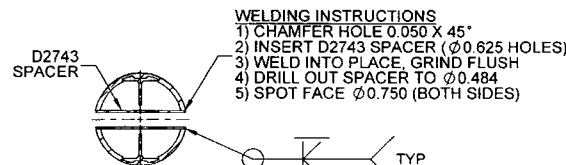
8 7 6 5 4 3 2 1



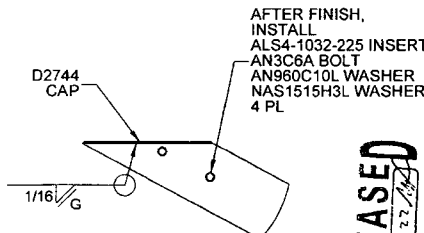
D2750-043 350 SKIDTUBE ASSEMBLY, LH



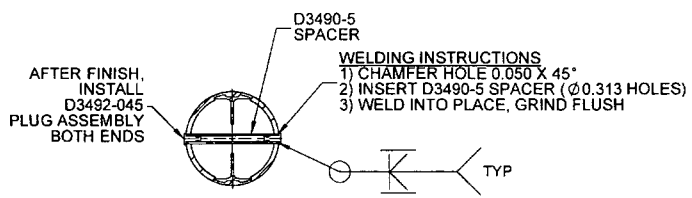
SECTION AT-AT
SCALE 3X, 4 PL



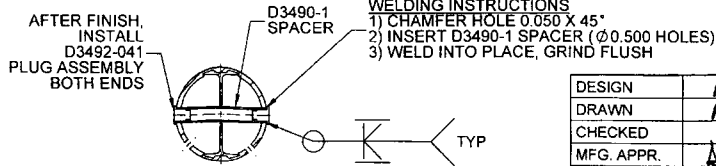
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



SECTION AU-AU
SCALE 3X, 4 PL



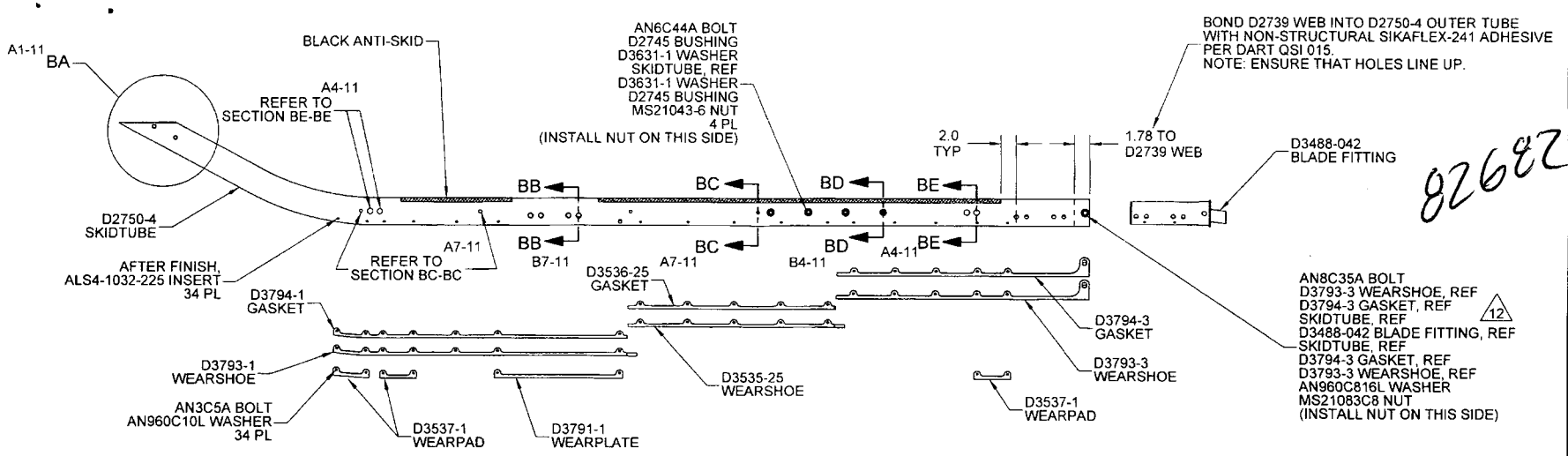
SECTION AW-AW
SCALE 3X, 4 PL

DESIGN	18	DART AEROSPACE USA, INC.	
DRAWN	18	PORT HADLOCK, WA	
CHECKED	18	DRAWING NO.	REV. F
MFG. APPR.	18	D2750	SHEET 10 OF 11
APPROVED	18	TITLE	SCALE
DE APPR.	18	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

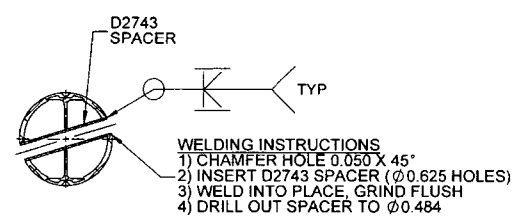
RELEASED
08-07-16

8 7 6 5 4 3 2 1

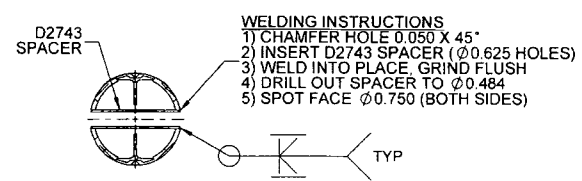
8 7 6 5 4 3 2 1



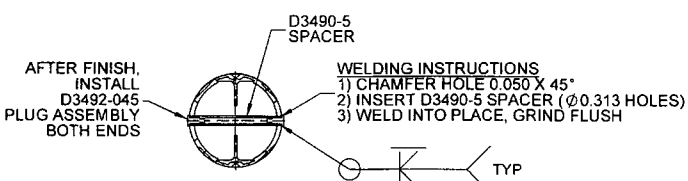
D2750-044 350 SKIDTUBE ASSEMBLY, RH



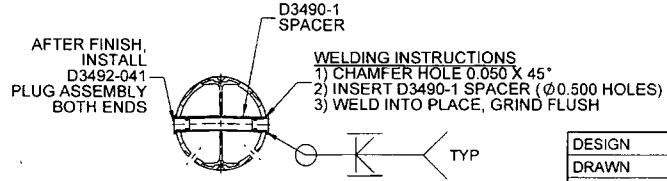
SECTION BB-BB
SCALE 3X, 4 PL



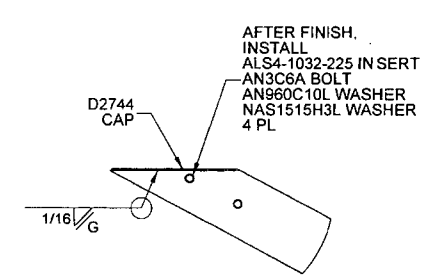
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NO. 300

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 87941
Part #: D350-636-011
Description: Seal
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier David David Date of Test Coupon 12.07.20
Welder Barclay Elliott Date of Test Coupon 12-07-24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld